

Work Order ID 64295

Page 1

Wednesday, December 01, 2010 1:23:17 PM

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 12/1/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-1

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3838	Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open
to finish size as per dwg D3838A/R ER316 S.S. Rod Batch: 111585

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838
A/R ER316 S.S. Rod Batch: 111585

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

10/12/08

(12)

10/12/08

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

10.12.08

2 0 BE 10/12/08

130



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

SAO
10-12-08

(2)

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Stop



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Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

140

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept

Qty

Reject
QtyReject
NumberInsp.
Stamp

QC

Quality Control

Memo

0.00

10/12/09 HJ

MF

10-12-08

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NOTE: Date & initial all entries

Picklist Print

Wednesday, December 01, 2010 1:23:21 PM

Page 1

Work Order ID: 64295



Parent Item: D3838-042



Parent Item Name: Cub Assembly (Basket Lid. RH)

Start Date: 12/1/2010

Required Date: 12/8/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1



Manufactured

No

100

Each

23.0000

1

2
CPL 10-12-07

Bushing

Location	Loc Qty	Loc Code
----------	---------	----------

ST084

3

56942

3

WA

20

54072

9

63876

11

M304TS0.750W.065



Purchased

No

100

f

1,062.852

1.0317

2.172



B103876 → 2

304 SQ Tube .75x.75x.065W

Location	Loc Qty	Loc Code
----------	---------	----------

MAT

1015.74795

112398

0

115494

4.4725

115593

11.27545

116267

1000

WA

47.104485

115274

4.712185

115901

42.3923

2.172

SAD 10-12-07

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8

7

6

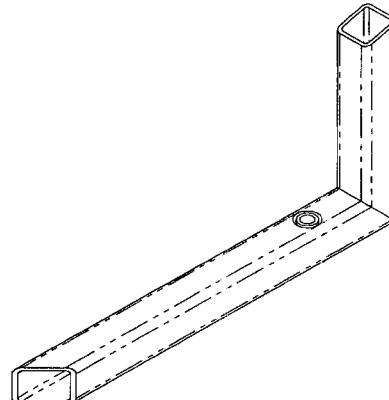
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4

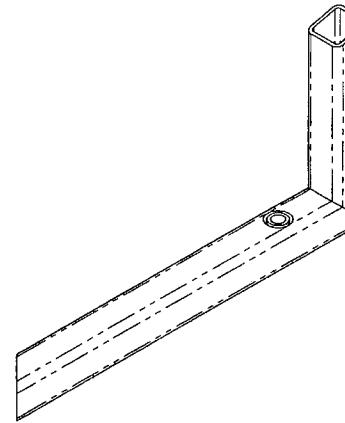
3

2

1



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

D

C

B

A

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

D

C

B

A

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 141293

PS 10-12-1

RELEASED
08/11/08

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PS</i>	DART AEROSPACE LTD	
DRAWN	<i>PS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PS</i>	D3838	SHEET 1 OF 3
APPROVED	<i>PS</i>	TITLE	SCALE
DE APPR.	<i>PS</i>	RIB ASSY (BASKET LID)	NTS
DATE	08.10.08	COPRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

8

7

6

5

4

3

2

1

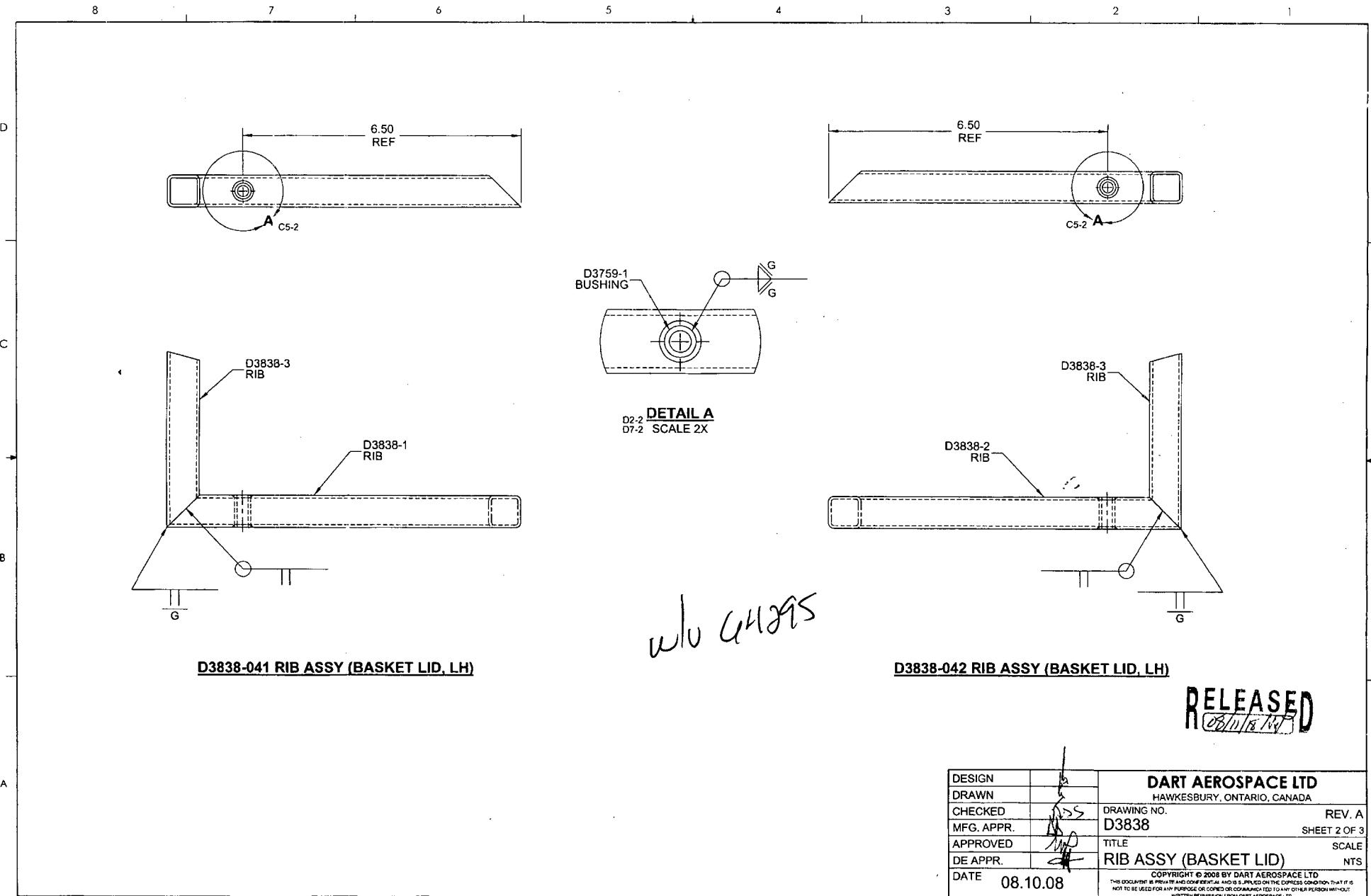
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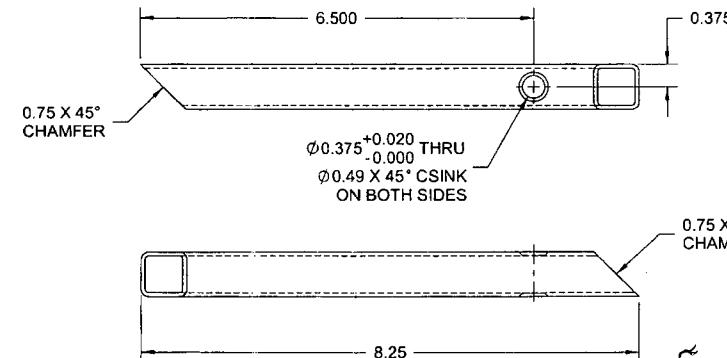
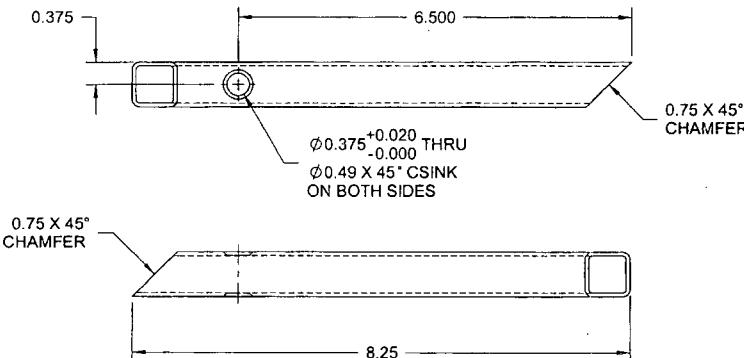
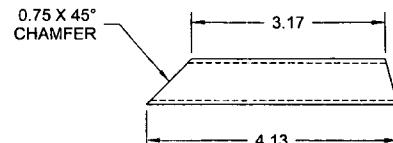
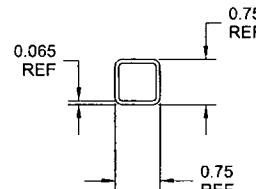
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8 7 6 5 4 3 2 1

D3838-1 RIBD3838-2 RIBD3838-3 RIBTYPICAL SECTION
VIEW

16489

RELEASED
08/11/08

A NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3838-1/2 = 0.35 lbs EACH; D3838-3 = 0.19 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>1A</i>	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>1A</i>	DRAWING NO. REV. A
MFG. APPR.	<i>1A</i>	D3838 SHEET 3 OF 3
APPROVED	<i>1A</i>	TITLE SCALE
DE APPR.	<i>1A</i>	RIB ASSY (BASKET LID) NTS
DATE	08.10.08	

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